

Date: Wednesday, 30/07/2008 9:19:55 AM
 User: Julie Lecocq

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : TURNING DETAIL FOR D2940-1 |
| Job Number | : 40801 | | |
| Estimate Number | : 13237 | | |
| P.O. Number | : | Part Number | : DSK081 |
| This Issue | : 30/07/2008 S.O. No. : | Drawing Number | : DSK081 REV.B |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : / / Type : MACHINED PARTS | Drawing Revision | : B |
| Previous Run | : 39686 | Material | : |
| Written By | : | Due Date | : 11/08/2008 |
| Checked & Approved By | : <u>JUL 08.7.30</u> | Qty: | ⑨ 10 Um: Each |
| Comment | : est rev A. 08.03.13 new issue EC | | |

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6104007

Round Billet, 17-4



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Billet

BATCH: 39627

20 08/08/08

⑨

2.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

Turn blank as per Folio FA079

26 08/08/12

⑨

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

26 08/08/14

⑨

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

28 08/08/20

⑨

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock in Kanban

Location: CNC

28 08/08/20

⑨

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/21

Job Completion



MF 08-08-20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|---|--------|---------------------|
| DART AEROSPACE LTD | | Work Order: 160801 |
| Description: Turning Detail for D2940-1 | | Part Number: DSK081 |
| Inspection Dwg: DSK081 | Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

| | | | | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | 5 |
| Lathe Section | | | | | | | | |
| A | 3.211 | 3.216 | | 3.216 | 3.216 | 3.216 | 3.216 | 3.216 |
| B | 4.946 | 4.966 | | 4.955 | 4.955 | 4.955 | 4.955 | 4.955 |
| C | 0.718 | 0.738 | | .728 | .728 | .728 | .728 | .728 |
| D | 0.090 | 0.110 | | .100 | .100 | .100 | .100 | .100 |
| E | 3.564 | 3.584 | | 3.574 | 3.574 | 3.574 | 3.574 | 3.574 |
| F | 0.022 | 0.042 | | .032 | .032 | .032 | .032 | .032 |
| G | 3.444 | 3.464 | | 3.454 | 3.454 | 3.454 | 3.454 | 3.454 |
| H | 0.112 | 0.132 | | .122 | .122 | .122 | .122 | .122 |
| I | 2.170 | 2.190 | | 2.180 | 2.180 | 2.180 | 2.180 | 2.180 |
| J | 4.451 | 4.471 | | 4.461 | 4.461 | 4.461 | 4.461 | 4.461 |
| K | 0.413 | 0.433 | | .423 | .423 | .423 | .423 | .423 |
| L | 0.913 | 0.933 | | .923 | .923 | .923 | .923 | .923 |
| M | | | | | | | | |
| N | | | | | | | | |
| O | | | | | | | | |
| P | | | | | | | | |

| | |
|---------------------|----------------|
| Measured by: 20 | Date: 08/08/14 |
| Audited by: 21 | Date: 08/08/20 |
| Prototype Approval: | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 08.04.22 | New Issue | KJ/JLM | |

| | | |
|---|--------|---------------------|
| DART AEROSPACE LTD | | Work Order: 40801 |
| Description: Turning Detail for D2940-1 | | Part Number: DSK081 |
| Inspection Dwg: DSK081 | Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

| | | | | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | 5 |
| Lathe Section | | | | | | | | |
| A | 3.211 | 3.216 | | 3.216 | 3.216 | 3.216 | 3.216 | 3.216 |
| B | 4.946 | 4.966 | | 4.955 | 4.955 | 4.955 | 4.955 | 4.955 |
| C | 0.718 | 0.738 | | .726 | .728 | .728 | .728 | .728 |
| D | 0.090 | 0.110 | | .100 | .100 | .100 | .100 | .100 |
| E | 3.564 | 3.584 | | 3.573 | 3.573 | 3.573 | 3.573 | 3.573 |
| F | 0.022 | 0.042 | | .032 | .032 | .032 | .032 | .032 |
| G | 3.444 | 3.464 | | 3.454 | 3.454 | 3.454 | 3.454 | 3.454 |
| H | 0.112 | 0.132 | | .122 | .122 | .122 | .122 | .122 |
| I | 2.170 | 2.190 | | 2.180 | 2.180 | 2.180 | 2.180 | 2.180 |
| J | 4.451 | 4.471 | | 4.461 | 4.461 | 4.461 | 4.461 | 4.461 |
| K | 0.413 | 0.433 | | .423 | .423 | .423 | .423 | .423 |
| L | 0.913 | 0.933 | | .923 | .923 | .923 | .923 | .923 |
| M | | | | | | | | |
| N | | | | | | | | |
| O | | | | | | | | |
| P | | | | | | | | |

Measured by: *28* Date: 08/08/11

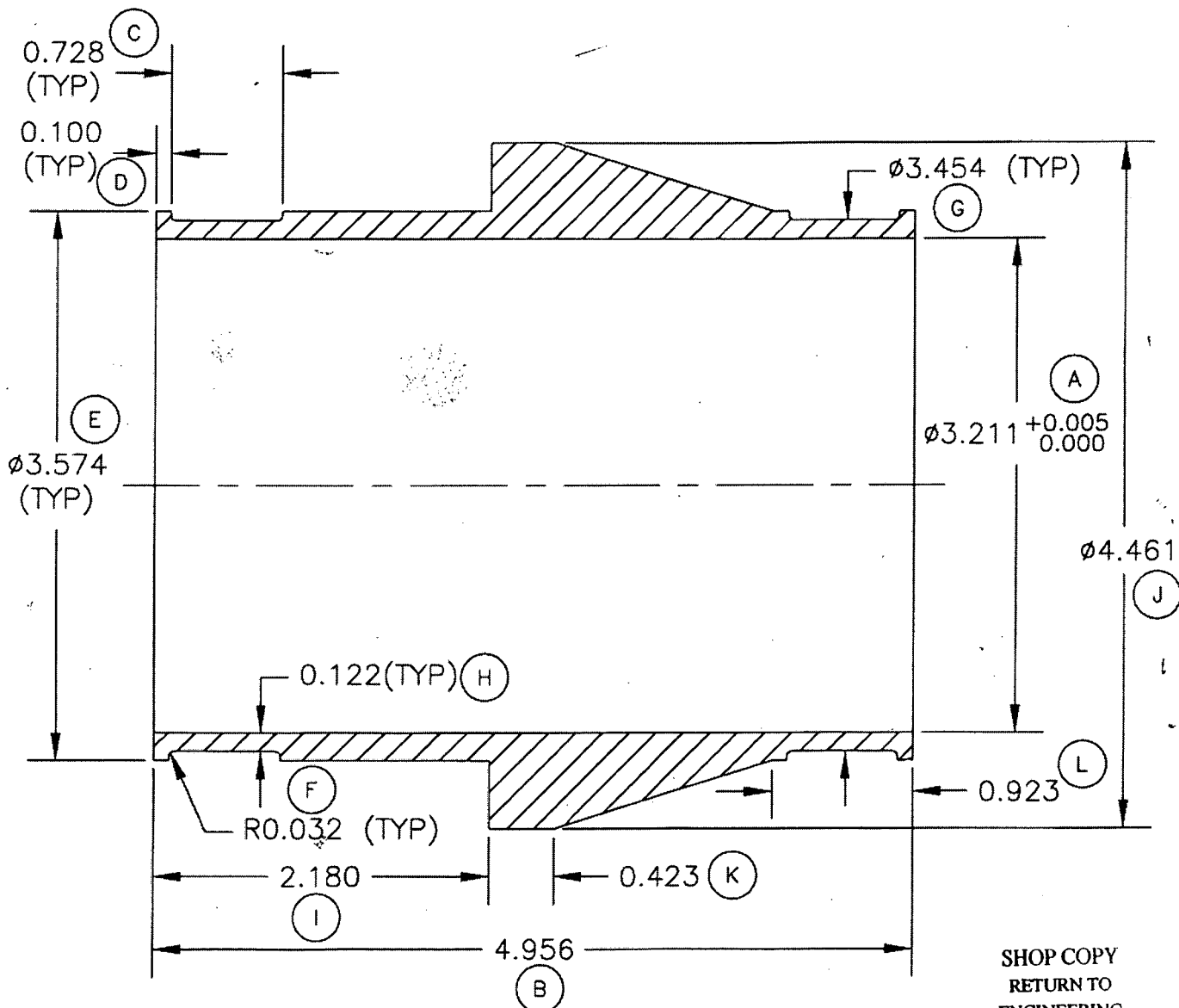
Audited by: *28* Date: 08/08/20

Prototype Approval: Date:

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|-----------|
| A | 08.04.22 | New Issue | KJ/JLM | <i>28</i> |



| | | | |
|------------------|---------------|---|------------------------|
| DESIGN RT | DRAWN BY H | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED H | APPROVED H | DRAWING NO. DSK 081 | REV. B SHEET 1 OF 1 |
| DATE 03.06.24 | | TITLE TURNING DETAIL FOR D2940-1 | SCALE 1:1 |
| A | 03.03.07 | NEW ISSUE | |
| B | 03.06.24 | ADDED 4.956 DIMENSION | |



D2940-1 TURNING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40801

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